

Work Order ID 74983***74983***

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October-14-11 10:18:52 AM

Item ID: D412-698-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener, LH/RH

Start Date: 14/10/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 26/10/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/10/14

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date:

SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

W 11-11-02 (4)
JG for MLJ 11-10-17
(4)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

11/10/17 (4)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

W 11-11-02 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>10B</u>								
	PPP Rev: <u>B</u>								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

MF 11-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 74983

74983

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 14/10/2011

Required Date: 26/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516L *AN960JD516I * Washer	NAS1149D0516J	Purchased	No	NAS1149D0516J		120	Each	0.0000	2	8			
									**	11/14/97			
D3552-11 *D3552-11* Door Prop		Manufactured	No			120	Each	10.0000	1				
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272		10							
					72239	10							
D3594-043 *D3594-043* Floor Doubler Assembly, LH		Manufactured	No			120	Each	15.0000	1				
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		2							
					73673	2							
				ST234B		13							
					67012	2							
					71690	10							
					73674	1							
D3594-044 *D3594-044* Floor Doubler Assembly, RH		Manufactured	No			120	Each	13.0000	1				
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST234B		13							
					71691	10							
					73672	2							
					73675	1							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

74983

D412-698-023

Start Date: 14/10/2011

Required Date: 26/10/2011

Start Qty: 4.00

Required Qty: 4.00

D3594-5

Manufactured No

120

Each

12.0000

1 4

D3594-5

Door Doubler

**

Location

Loc Qty

Loc Code

ST234A

12

71692

12

120

Each

1.0000

2 8

D3622-1

Manufactured No

D3622-1

Ball Stud

**

Location

Loc Qty

Loc Code

ST070

1

72102

1

120

Each

1,721.000

2 8

MS20426AD4-4

Purchased

No

MS20426AD4-4

Rivet

**

Location

Loc Qty

Loc Code

ST317

1721

116188

1721

120

Each

83.0000

1 4

MS21073L5

Purchased

No

MS21073L5

nut plate

**

Location

Loc Qty

Loc Code

ST302

83

117395

83

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH)
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH)
	2	D3622-1	BALL STUD)
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET)
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01